

Work Order ID 165102***165102***

Page 1

Tuesday, August 15, 2017 3:18:20 PM

Item ID: D4634-145 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Replacement Panel Assembly
Start Date: 8/21/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 8/25/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: AUG 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								

100

0.00

100

HandThermo

Memo

0.83

Hand Finishing Thermoforming

Pick Kit

SEP 08 2017

DAS
6
9-89

110

0.00

110

Small Fab

Memo

1.31

Small Fab

Assemble as per Dwg D4634-145

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # 137679.Expiry Date Sept 27/17.

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

DAS
07
9-89

17/09/17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Work Order ID 165102

Tuesday, August 15, 2017 3:18:20 PM

165102

Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

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Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/25/2017 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.01							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							

SMB
17/9/18DAS
07
9-89

17/09/18

17/9/20

SEP 18 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 165102

165102

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4636-5 *D4636-5* Bracket		Manufactured	No			100	Each	37.0000	1	1		SEP 09 2017	DAS 6 8-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST115	37								
				154916	17								
				<u>164519</u>	20								
D4712-1 *D4712-1* Bracket		Manufactured	No			100	Each	2.0000	1	1		SEP 09 2017	DAS 6 8-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				MF004	2								
				163711	2								
D5021-5 *D5021-5* Foam, Center Panel, Aft		Manufactured	No			100	Each	2.0000	1	1		SEP 09 2017	DAS 6 8-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST479a	2								
				<u>164048</u>	2								

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WORK ORDER NON-CONFORMANCE / UPDATE



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Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 165102

165102

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased

No

100

Each

99.0000

2

2

MS21059L08

Nut

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST300

99

m134943

1

m136554

98

MS20426AD3-4

Purchased

No

100

Each

7,218.000

4

4

MS20426AD3-4

RIVET

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

5644

m134294

1921

m136444

3723

ST312

1574

m131697

48

m134294

1526

MS20426AD4-6

Purchased

No

100

Each

984.0000

2

2

MS20426AD4-6

Rivet

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK004

861

M137851

861

GA

37

M134502

25

M137851

12

ST311

86

M136537

86

D4634-5

Manufactured

No

100

Each

0.0000

1

1

D4634-5

Aft, Center Ceiling Panel

**

W0 16429C

2
①

DAS
07
9-89
17/09/12

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Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Work Order ID: 165102

165102

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

D4647-1

Manufactured No

100 Each

4.0000 1 1

D4647-1

Doubler

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF004

4

155284

4

D4664-5

Manufactured No

100 Each

9.0000 6 6

D4664-5

Spacer

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF004

9

155824

9

D4732-17

Manufactured No

100 Each

2.0000 1 1

D4732-17

Label

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF005

2

159497

2

D4732-23

Manufactured No

100 Each

2.0000 1 1

D4732-23

Label

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF005

2

123211

2

D4732-27

Manufactured No

100 Each

2.0000 1 1

D4732-27

Label

**

SEP 09 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF005

2

123213

2

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

MPNY-750S-9-C

Purchased

No

100

Each

603.0000

9

9

MPNY-750S-9-C

SEP 09 2017

Mounting Pad

Location

Loc Qty

Loc Code

ST569

603

M130423

603

9

DQA: _____ Date: _____

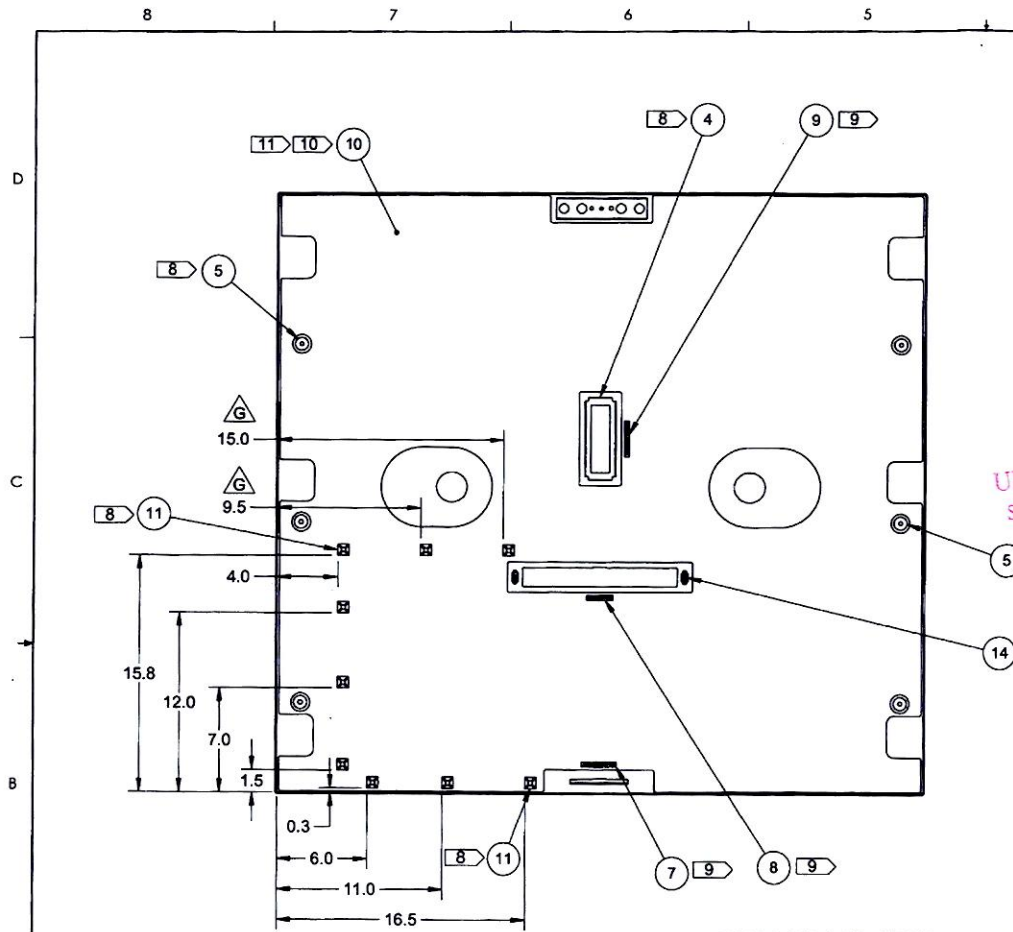


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

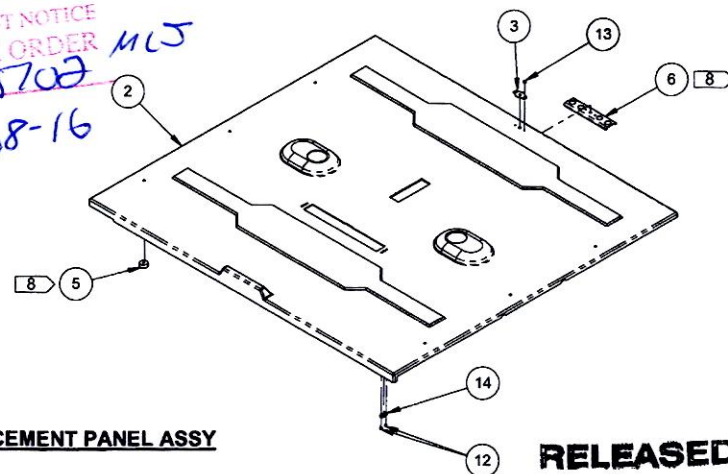
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Misidentified ☐	Past Due ☐																																																																



D4634-145 AFT, CENTER CEILING REPLACEMENT PANEL ASSY

ITEM	QTY -145	P/N	DESCRIPTION
1	X	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4684-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-(4)	RIVET, SOLID, CSK
13	2	MS20426AD4-(6)	RIVET, SOLID, CSK
14	2	MS21059L08	NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 165702
1708-16



RELEASED
2015 JAN 26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-5 FOAM ON D4634-5

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G
MFG. APPR.	DL	SHEET 9 OF 17	
APPROVED	HS	SCALE	
DE APPR.	DS	CENTER CEILING PANELS	
DATE	14.11.28	NTS	

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